



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-642-211
Job Sheet 178925



Part No: D206-642-211

Job Qty: 1 ea

Part Name: Skidtube LH, High Gear with Standard Wearplates (2.5" Bolt Spacing on Aft Saddle)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV Q SHEET 27 IPP Rev:J 04.08.06 Revised Step 4 per CHG003 KJ/JLM J 04.08.06 IPP Rev:K 07-12-04 ECN 1080p DD verified by: IPP rev L 10.02.02 per IIN rev M EC verified by: JLM IPP REV:M 11.11.17 PER IIN REVO DD VERF;EC IPP Rev:N 12.11.21 ECN12-679 DD verf:JLM IPP Rev:C 14.04.24 ECN14-520 DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Stores/Pkg-1	DAS		JUL 06 2018
110	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging1-2	DAS69		JUL 06 2018
120	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC4	469-89 DAS		DEC 06 2018
130	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-1	9-89 46		DAS
135	DC	1 pcs	7/6/18	7/6/18	0.00	0.00	DC	9-89		21 DEC 06 2018
140	QC21-FG	1 Ea	7/6/18	7/6/18	0.00	0.00	QC21			21 9-89 DEC 06 2018

Part Op 130 - Identify and pack for shipping as per PPP D206-642-211
Descriptions: 135 - Photocopy bluefile & type labels per PPP206-642-211 CHG008

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	5038750
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	5058982
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	5019407
AN5-11A	Bolt	4 Ea (4 ea)	90-Start up Operation	5003927
AN5-7A	Bolt	4 Ea (4 ea)	90-Start up Operation	5026233
AN6-44A	Bolt	2 Ea (2 ea)	90-Start up Operation	5077528
D206-651-041	206 A/B Ground Handling Wheel	1 Ea (1 ea)	90-Start up Operation	5071508
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	5070855
D2665-1	Saddle, LH Fwd Aft Out	2 Ea (2 ea)	90-Start up Operation	5070855
D2666-1	Saddle, LH, Fwd, Aft, In	2 Ea (2 ea)	90-Start up Operation	5022303
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	5022936
D2884	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5031303

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation	Disposition

By _____ Supervisor _____ Coordinator _____

DART AEROSPACE

Container No: S089768
 Part: D206-642-211
 Job No: 178925
 Serial No/Batch: S089768

Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____

Date: 07/06/18

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K5A 1K7
 TEL: 416-513-692-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause		FAULT CATEGORY	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

D2885	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	3054580
D3413-1	O-Ring	1 Ea (1 ea)	90-Start up Operation	5068698
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	5078167
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	5062378
MS21042L6	Nut	2 Ea (2 ea)	90-Start up Operation	5041168
NAS1149C0463R	Washer	1 Ea (1 ea)	90-Start up Operation	5053953
NAS1149D0363J	Washer	8 Ea (8 ea)	90-Start up Operation	5015289
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation	5062378
NAS1149D0563J	Washer	8 Ea (8 ea)	90-Start up Operation	5068602
NAS1149D0663J	Washer	4 Ea (4 ea)	90-Start up Operation	5043782
D206-642-241	Replacement Skidtube,High Gear with Standard Wearplates Fits LH or RH	1 Ea (1 ea)	110-Packaging	5126818

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	219	0
	AN4-6A	12	1,368	0
	AN4C5A	1	75	0
	AN5-11A	4	175	0
	AN5-7A	4	3,430	0
	AN6-44A	2	138	0
	D206-651-041	1	5	0
	D2652	16	501	0
	D2665-1	2	4	0
	D2666-1	2	8	0
	D2712	10	739	0
	D2884	2	28	0
	D2885	2	38	0
	D3413-1	1	44	0
	MS21042L3	8	1,881	0
	MS21042L4	12	2,959	0
	MS21042L6	2	238	0
	NAS1149C0463R	1	253	0
	NAS1149D0363J	8	2,225	0
	NAS1149D0463J	24	5,122	0
	NAS1149D0563J	8	2,091	0
	NAS1149D0663J	4	779	0
110-Packaging	D206-642-241	1	2	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004249	S089740	AN3-41A	Bolt	S038750	ST347	8
004249	S089741	AN4-6A	Bolt	S058982	ST345	12
004249	S089742	AN4C5A	Bolt	S019407	ST345	1
004249	S089743	AN5-11A	Bolt	S003927	ST338	4
004249	S089744	AN5-7A	Bolt	FM123355	OVER009	4
004249	S089745	AN6-44A	Bolt	F123265	ST333	2
004249	S071508	D206-651-041	206 A/B Ground Handling Wheel	S064560	ST365	1
004249	S089747	D2652	Bushing	S054607	ST009	16
004249	S089748	D2665-1	Saddle, LH Fwd Aft Out	S070835	ST402	2
004249	S089750	D2666-1	Saddle, LH, Fwd, Aft, In	S070865	ST402	2
004249	S089751	D2712	Set Screw	S031303	ST010	10
004249	S089752	D2884	Saddle Spacer	S022936	ST013	2
004249	S089753	D2885	Saddle Spacer	S054580	ST013	2
004249	S089755	D3413-1	O-Ring	S068698	ST530	1
004249	S089756	MS21042L3	Nut	S078167	ST303	8
004249	S089757	MS21042L4	Nut	S062378	ST303	12
004249	S089758	MS21042L6	Nut	S041168	ST303	2
004249	S089759	NAS1149C0463R	Washer	S053953	ST266	1
004249	S089760	NAS1149D0363J	Washer	S015269	ST263	8
004249	S089761	NAS1149D0463J	Washer	S062379	ST263	24
004249	S089762	NAS1149D0563J	Washer	S068662	ST263	8
004249	S089764	NAS1149D0663J	Washer	S043782	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 7/6/18 2:35 PM dart.quirion.sonia

Change Record

PAGE 1 OF 1

Part Number: D206-642-211/-212

Description: SKIDTUBE , LH/RH

[illegible]

4.3 206A/B HIGH GEAR SKIDTUBES

ITEM	QTY -211	QTY -212	QTY -213	QTY -214	QTY -241	QTY -257	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
1	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-257	WEARSHOE KIT (REPLACES -247)
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER ⁽³⁾
1					1		D2650-3	SKIDTUBE ASSEMBLY
2A					18		D2651-1	* PLUG ⁽¹⁾
2B					18		D2651-3	* O-RING ⁽¹⁾
3					1		D2646	* AFT CAP ⁽¹⁾
4					2		MS27039-1-08	* SCREW ⁽¹⁾
5					2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1				D2665-1	SADDLE, FWD OUT, LH
6		1		1			D2665-2	SADDLE, FWD OUT, RH
7	1		1				D2666-1	SADDLE, FWD IN, LH
7		1		1			D2666-2	SADDLE, FWD IN, RH
8	1						D2665-1	SADDLE, AFT OUT, LH
8		1					D2665-2	SADDLE, AFT OUT, RH
8			1				D2667-1	SADDLE, AFT OUT, LH
8				1			D2667-2	SADDLE, AFT OUT RH
9	1						D2666-1	SADDLE, AFT IN, LH
9		1					D2666-2	SADDLE, AFT IN, RH
9			1				D2668-1	SADDLE, AFT IN, LH
9				1			D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8			AN3-41A	BOLT
11	16	16	16	16			D2652	BUSHING
12A	8	8	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4			AN5-7A	BOLT
14	4	4	4	4			AN5-11A	BOLT
14A			2	2			AN5-32A	* BOLT ⁽²⁾
14B			2	2			MS21042-5	* NUT (OR MS21042L5) ⁽²⁾
15	8	8	8	8			NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12			AN4-6A	BOLT
17	24	24	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12			MS21042-4	NUT (OR MS21042L4)
20A					4	4	D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1	D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1	D4956-13	WEARSHOE (REPLACES D3535-13 + D3536-13)
23A					1	1	D4956-21	WEARSHOE (REPLACES D3535-21 + D3536-21)
24A					1	1	D4956-33	WEARSHOE (REPLACES D3535-33 + D3536-33)
26A					44	44	MS27039C1-08	SCREW
26B					44	44	NAS1149C0332R	WASHER (OR AN960C10L)
26C					44		ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
28	2	2	2	2			AN6-44A	BOLT
29A	2	2	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4	4	4			NAS1149D0663J	WASHER (OR AN960JD616)
34	1	1	1	1			AN4C5A	BOLT
35	1	1	1	1			NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1			D3413-1	RING (REPLACES D2655)
37	10	10	5	5			D2712	SET SCREW
38	2	2	2	2			D2884	SADDLE SPACER
39	2	2	2	2			D2885	SADDLE SPACER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-3 ASSEMBLY ABOVE⁽²⁾ MAY BE REQUIRED ON -213/-214 INSTALLATIONS⁽³⁾ NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS

• COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: Q

Date: 13.08.12

REFERENCE ONLY

